

Date: Thursday, 2/9/2006 1:53:32 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MECHANICAL GROUND HANDLING WHEEL KIT	
Job Number :	25780	Part Number :	D206731041	
Estimate Number :	12136	Drawing Number :	IIN-D206-731 pg 4,6	
P.O. Number :	N/A	Project Number :	N/A	
This Issue :	2/9/2006	S.O. No. :	N/A	
Prsht Rev. :	NC	Drawing Revision :	A	
First Issue :	N/A	Material :	N/A	
Previous Run :	25779	Due Date :	3/30/2006	Qty: 1 Um: Each
Written By :				
Checked & Approved By :	06.02.10			
Comment :	est rev. A 01.02.01 new issue EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33355	spring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3335-5	spring	

325809

Ppl 06-08-25

2.0	D3353042	LUG ARM WELDMENT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3353-042	LUG ARM WELDMENT	

325803

Ppl 06-08-25

3.0	D3354041	LEFT ARM WELDMENT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3354-041	Left Arm Weldment	

325910

Ppl 06-08-25

4.0	D33561	pin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3356-1	pin	

325912

Ppl 06-08-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:53:32 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 25780

Part Number: D206731041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D3397041

wheel ass'y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description
2	D3397-041	Wheel ass'y

batch

B25804

PLC 06.09.06

6.0

113800

GREASE FITTING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	113-800	GREASE FITTING

batch

M101058

PLC 06.08.25

7.0

656051

flat washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description
2	656-051	flat washer

batch

M17413

PLC 06.08.25

8.0

663079

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	663-079	Lock washer

batch

M16362

PL 06.08.25

9.0

AN523A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	AN5-23A	Bolt

batch

M19278

PL 06.08.25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 25780

Part Number: D206731041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	AN960JD516L	Washer

batch

M101369

Cpl 06-08-25

11.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description
2	<i>SNF-34</i>	1/8" Cotter Pin 2" long

batch

M16301

Cpl 06-08-25

12.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	MS21042L5	Nut

batch

M101648

Cpl 06-08-25

13.0

SNF34

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description
<i>2</i>	SNF-34	<i>1/8" Cotter Pin 2" long</i>

batch

M16354

Cpl 06-08-25

14.0

TP2

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	TP-2	Spring pin

batch

M16588

Cpl 06-08-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 04/08/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:53:32 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 25780

Part Number: D206731041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

qty	Part Number	Description
1	TP-134	Spring pin

batch

m16362

Cpl 06.08.25

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per dwg

Cpl 06.09.02

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease.

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.09.07

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

19.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/15
U 0609-15

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

4.0 PARTS LIST

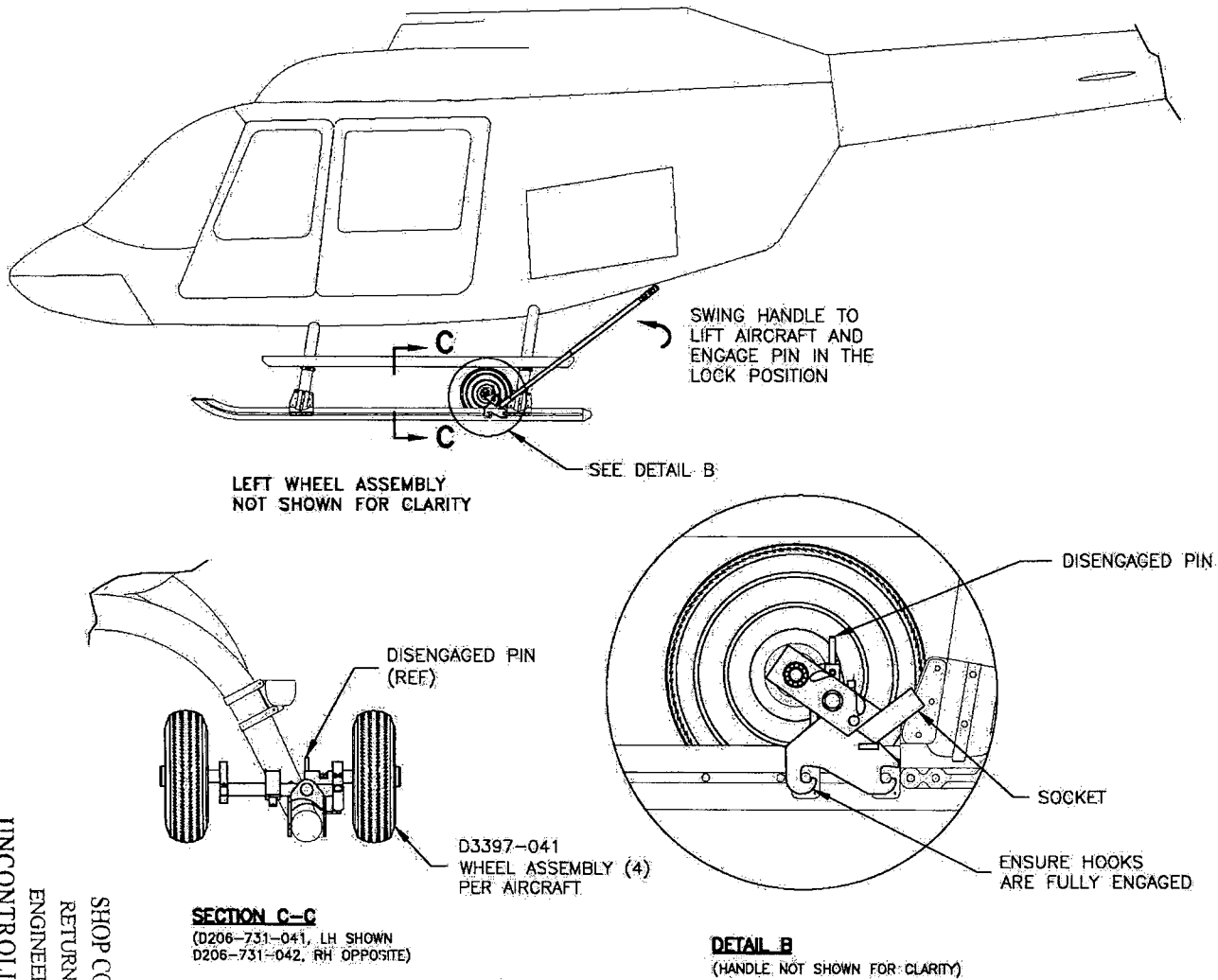
QTY -011	QTY -041	QTY -042	Part Number	Description
X			D206-731-011	MECHANICAL GROUND HANDLING WHEEL KIT
1	X		D206-731-041	MECHANICAL GROUND HANDLING WHEEL (LH)
1		X	D206-731-042	MECHANICAL GROUND HANDLING WHEEL (RH)
	1	1	D3335-5	* SPRING
		1	D3353-041	* LUG ARM WELDMENT
	1		D3353-042	* LUG ARM WELDMENT
	1		D3354-041	* LEFT ARM WELDMENT
		1	D3354-042	* MIRROR ARM WELDMENT
1			D3355-041	* HANDLE ASSEMBLY
	1	1	D3356-1	* PIN
	2	2	D3397-041	* WHEEL ASSEMBLY
1			D3381-1	** LABEL
	1	1	113-800	* GREASE FITTING
	2	2	656-051	* FLAT WASHER
	1	1	663-079	* LOCK WASHER
	1	1	AN5-23A	* BOLT
	1	1	AN960JD516	* WASHER
	2	2	CP-21	* COTTER PIN
	1	1	MS21042L5	* NUT
	2	2	SNF-34	* SLOTTED NUT
	1	1	TP-2	* SLOTTED SPRING TENSION PIN
	1	1	TP-134	* SLOTTED SPRING TENSION PIN

* shown for reference only, part is included in D206-731-041/ -042 assemblies above

** shown for reference only, part is included in D3355-041 assembly above

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NO. 25780

PRELIMINARY ISSUE



**Figure 2 – D206-731-041 Mechanical Ground Handling Wheel Installation
(Left Side Shown, Right Side Opposite)**

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